

Work Order ID 59732

Thursday, June 10, 2010 9:58:58 AM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 6/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-6-10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

0.00



Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
- 5- weld bushing as per dwg D3916
- 6- grind welds flush

(6) SH 10/06/29

SAD 10-06-22

110

QC5- Inspect part completeness to step on W/O

0.00



QC

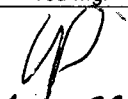
Memo

0.00

Quality Control

Sobal30

(x6)

| W/O: 59732 | | WORK ORDER CHANGES | | | | | | |
|------------|------|--|-----|----------|-----|---|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 10.06.22 | 100 | OK to have the weld seam on inside of bend. VERIFY THAT THERE ARE NO MAJOR RIPPLES | SAD | 10-06-22 | ① |  10.06.22 051042 | | |
| | | | | | | | | |

Part No: D3916-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Setup Start



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Stop



Start Date: 6/10/2010 Start Qty: 6.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | | | | <u>66</u> | | | |
| 130 Packaging Packaging | Identify as per dwg & Stock Location: <u>WA</u> Memo | 0.00 0.00 | | | | <u>6</u> | | | |
| 140 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

81064/30

SAD
10-06-30

10/06/30 HJ

MF 10-6-30

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 10, 2010 9:59:16 AM

Page 1

Work Order ID: 59732

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Date: 6/10/2010

Required Date: 6/17/2010

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3759-1 | | Manufactured | No | | | 100 | Each | 16.0000 | 7 | 42 | | | |



Bushing

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 16 | |
| 54072 | 9 | |
| 58672 | 7 | |

M304TS0.750W.049

Purchased

No

100 f

315.5414

4.166

26.31158



304 SQ Tube .75x.75x.049W

| Location | Loc Qty | Loc Code |
|----------|-------------|----------|
| MAT | 315.5413419 | |
| 113763 | 0 | |
| 114323 | 29.3546289 | |
| 114677 | 27.30236 | |
| 114835 | 258.884353 | |
| MAT017 | 3.68448E-05 | |
| 114298 | 3.6845E-05 | |



B59419 (30)

B59644 (12)

10/06/20



S40

10-06-22

26.31158

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

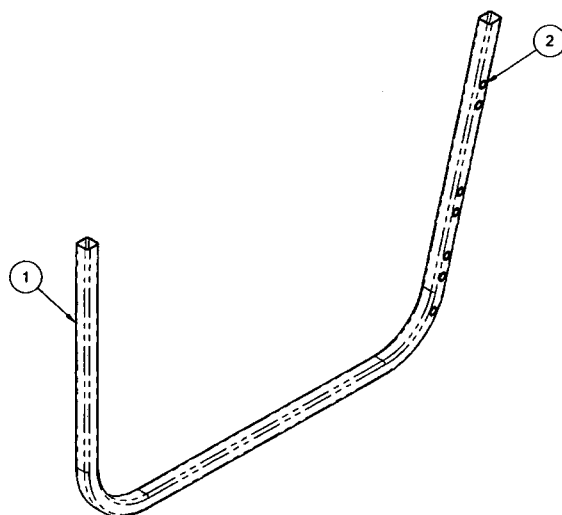
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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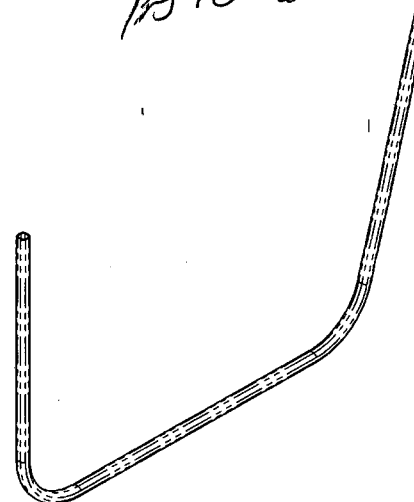
NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|-------------|
| | X | D3916-041 | RIB ASSY |
| 1 | 1 | D3916-1 | RIB |
| 2 | 7 | D3759-1 | BUSHING |

RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 59732
PS 10-6-10



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

RELEASED
 2010-03-12
MP

| | | | |
|------------|--------------------|---|--------------|
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D3916 | SHEET 1 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | RIB ASSY, 350 BASKET | NTS |
| DATE | 10.03.04 | COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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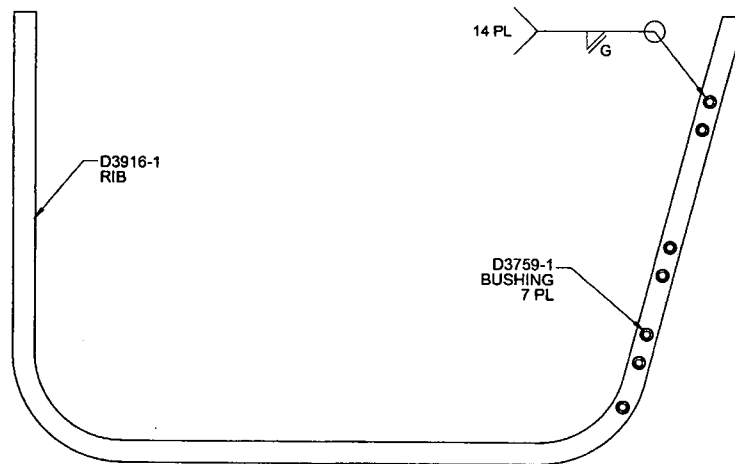
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NOTE: Date & initial all entries

W/O 59732



D3916-041 RIB ASSY

RELEASED
2010-03-12
NTP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D3916 | SHEET 2 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
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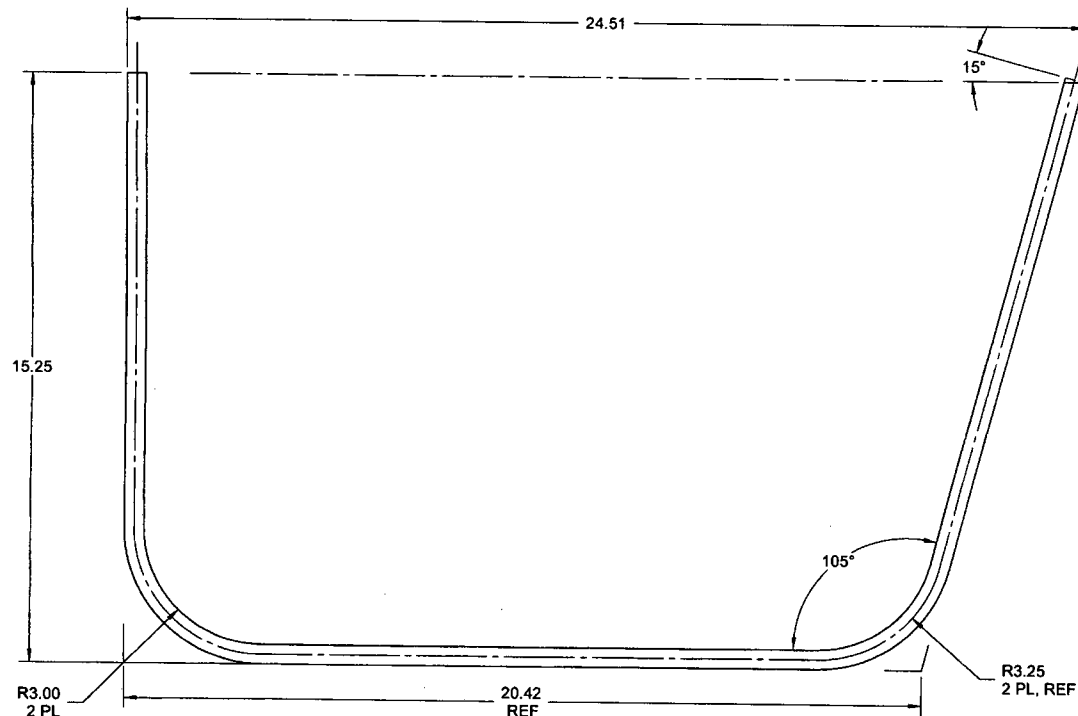
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NOTE: Date & initial all entries

W 10 59732



9 D3916-5 LIGHT RIB

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

| | | | |
|--|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JP | DRAWING NO. | REV. A |
| MFG. APPR. | JP | D3916 | SHEET 4 OF 4 |
| APPROVED | JP | TITLE | SCALE |
| DE APPR. | JP | RIB ASSY, 350 BASKET | NTS |
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